



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBEM622U3001101-11
Job Sheet 181880



Part No: RBEM622U3001101-11 Job Qty: 6 ea

Part Name: Hex Head Cap Screw



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 8/10/18

Job Tracking No:

Due Date: 8/20/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBEM622U3001101 Rev. 2 IPP Rev. A 18.06.26 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	8/20/18	8/20/18	0.00	0.00	Start Up Machining-4		DTP 18-09-26
100	Lathe Conv	6 pcs	8/20/18	8/20/18	0.00	0.40	Lathe Conv-2		DTP 18-09-26
110	QC	6 pcs	8/20/18	8/20/18	0.00	0.00	QC2 Machining-5		DTP 18-09-26
120	QC	6 pcs	8/20/18	8/20/18	0.00	0.00	QC8 Machining-5		DTP 18-09-26
130	Outsource	6 pcs	8/20/18	8/20/18	0.00	0.00	Outsource12		DTP 18-09-26
140	Packaging	6 pcs	8/20/18	8/20/18	0.00	0.00	Packaging2		DTP 18-09-26
150	QC	6 pcs	8/20/18	8/20/18	0.00	0.00	QC6		DTP 18-09-26
160	Packaging	6 pcs	8/20/18	8/20/18	0.00	0.00	Packaging3-2		DTP 18-09-26
170	QC21-SA	6 Ea	8/20/18	8/20/18	0.00	0.00	QC21		DTP 18-09-26

Part Op 100 - 1-Machine as per DWG. 2-Debur

Descriptions: 130 - -Issue P/O to GROUPE ALTECH; PO 041195 -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material; Bolt -Certificate of Conformity is required

140 - Receive

160 - IDENTIFY AND STOCK

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
38417	Hex Head Cap Screw, Steel, M8 X 1mm X 80mm	6 Ea (1 ea)	90-Start up Operation	5093918 GA060

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	38417	6	10	0



Container No: S113675



Part: RBEM622U3001101-11

Job No: 181880

Serial No/Batch: S113675

Revision: 2

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL : 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Part Specifications

Specifications could not be found.

Plex 9/25/18 12:51 PM Dart.lajeunesse.marie

Date: 09/26/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

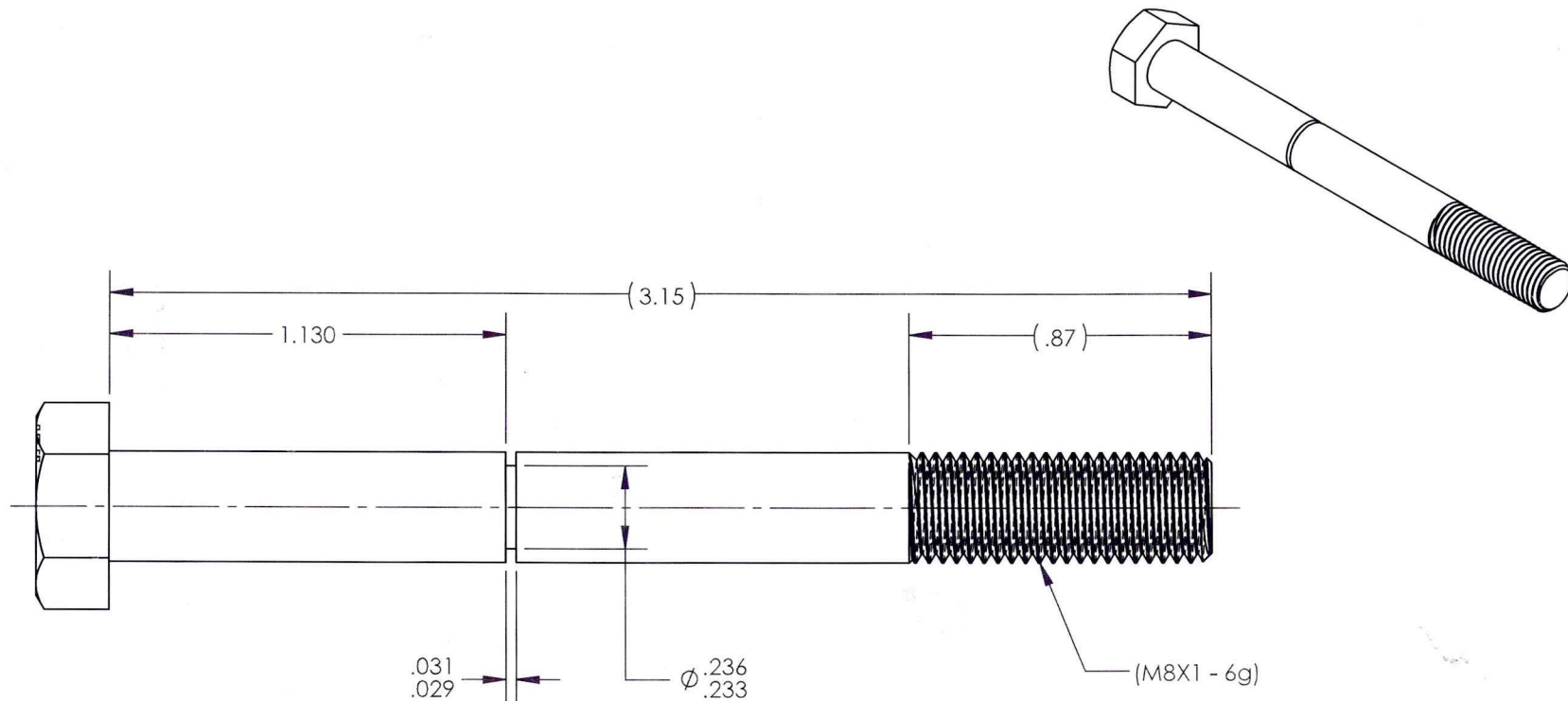
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0172	-11 CH'D FINISH WAS QMSI-6.2.2, REV D IS QSMI-6.2.2, B.O. REV D.	10/14/2016	RJC	SM



(-11)

HEX HEAD CAP SCREW

DART AEROSPACE	
TITLE CONICAL EXTRACTOR	
DWG NO. RBEM622U3001101-11	REV 2
MAT'L STEEL	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH BLACK OXIDE	.XX ± .01 ANGLES ± 5°
SPEC QMSI-6.2.2, B.O. REV D	.X ± .1 SURFACES = 125
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: MACKOVJAK	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H175
SCALE 2:1	DATE 4/15/2016
SHEET 7 OF 11	



Dart Aerospace Ltd.
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Tel (613) 632-5200

PURCHASE ORDER PO041195

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO041195
PO Date: 10/1/18
Due Date: 10/12/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:
Via: Ground
Pynt Terms: Net 60
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	181886	RBEM622U3001101-9	Extractor Bottom -Issue P/O to GROUPE ALTECH; PO -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 1018 -Certificate of Conformity is required	Firmed	-	10/12/18	2 pcs	0 pcs	2 pcs	\$1.65/pcs	\$3.30

2x

OCT 12 2018



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PURCHASE ORDER

PO041195

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
2	181880	RBEM622U3001101-11	Hex Head Cap Screw -Issue P/O to GROUPE ALTECH; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-C-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material; Bolt -Certificate of Conformity is required	Firmed	-	10/12/18	6 pcs	0 pcs	6 pcs	\$1.25/pcs	\$7.50
3	182801	RBEM632V4000102-7	Socket Head Cap Screw -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	10/12/18	6 pcs	0 pcs	6 pcs	\$1.25/pcs	\$7.50
4	180029	RBE350A93-3307-00-01	Retractor -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13964, CLASS 1; MIL-C-16173 GRADE 4 -Certificate of Conformity is required	Firmed	-	10/12/18	21 pcs	0 pcs	21 pcs	\$2.55/pcs	\$53.55
5	179429-A	RBE350A93-3303-02-1	Receiver Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	10/12/18	18 pcs	0 pcs	18 pcs	\$5.41/pcs	\$97.38

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PURCHASE ORDER **PO041195**

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
6	177794	RBEM652V3002101-M-45	Stud Extension -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-C-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Certificate of Conformity is required	Firmed	-	10/12/18	11 pcs	0 pcs	11 pcs	\$2.35/pcs	\$25.85
7	181644	RBE350A94-2706-00-09	Pin -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	10/12/18	21 pcs	0 pcs	21 pcs	\$1.55/pcs	\$32.55
8	181639	RBE350A94-2706-00-07	Pin -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	10/12/18	30 pcs	0 pcs	30 pcs	\$1.50/pcs	\$45.00
9	181640	RBE350A94-2706-00-03	Pin -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	10/12/18	53 pcs	0 pcs	53 pcs	\$1.50/pcs	\$79.50
Grand Total:											\$352.13



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PURCHASE ORDER PO041195

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 10/2/18 3:34 PM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance

(013148-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

013148 - 1

Livré à / Ship to

DART AEROSPACE LTD

1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD

1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
11-Oct-2018		Aman		041195 ✓				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBEM622U3001101-9 ✓ Rev.	RBEM622U3001101-9 01-OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY A THIN LAYER OF OIL MIL-PRF-16173 GRADE 3 CLASS 1 WIPE OF EXCESS OIL	OXIDE-BLACK CH	2	2 ✓	0	0	0
2	RBEM622U3001101-11 ✓ Rev.	RBEM622U3001101-11 01-OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY A THIN LAYER OF OIL MIL-PRF-16173 GRADE 3 CLASS 1 WIPE OF EXCESS OIL	BLACK-OXIDE CH	6	6 ✓	0	0	0
3	RBEM632V4000102-7 ✓ Rev.	RBEM632V4000102-7 01-OXIDE BLACK per MIL-C-13924, Class 1	OXIDE-BLACK CH	6	6 ✓	0	0	0
4	RBE350A93-3307-00-01 ✓ Rev.	RBE350A93-3307-00-01 01-OXIDE BLACK [OXIDE BLACK] MIL-C-13964 CLASS 1, MIL-C-16173 GRADE 4	OXIDE-BLACK CH	21	21 ✓	0	0	0
5	RBE350A93-3303-02-1 ✓ Rev.	RBE350A93-3303-02-1 01-BLACK OXIDE FINISH M MIL-C-13924C, CLASS 1	BLACK-OXIDE CH	18	18 ✓	0	0	0
6	RBEM652V3002101-M-45 ✓ Rev.	RBEM652V3002101-M-45 01-OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY A THIN LAYER OF OIL MIL-PRF-16173 GRADE 3 CLASS 1 WIPE OF EXCESS OIL	OXIDE-BLACK CH	11	11 ✓	0	0	0
7	RBE350A94-2706-00-09 ✓ Rev.	RBE350A94-2706-00-09 01-OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	21	21 ✓	0	0	0
8	RBE350A94-2706-00-07 ✓ Rev.	RBE350A94-2706-00-07 01-OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	30	30 ✓	0	0	0
9	RBE350A94-2706-00-03 ✓ Rev.	RBE350A94-2706-00-03 01-OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	BLACK-OXIDE CH	53	53 ✓	0	0	0

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